



**FOR THE PURPOSES OF INFORMATION ONLY**

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece	ML	Mali	TR	Turkey
BG	Bulgaria	HU	Hungary	MN	Mongolia	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MR	Mauritania	UA	Ukraine
BR	Brazil	IL	Israel	MW	Malawi	UG	Uganda
BY	Belarus	IS	Iceland	MX	Mexico	US	United States of America
CA	Canada	IT	Italy	NE	Niger	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NL	Netherlands	VN	Viet Nam
CG	Congo	KE	Kenya	NO	Norway	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NZ	New Zealand	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	PL	Poland		
CM	Cameroon	KR	Republic of Korea	PT	Portugal		
CN	China	KZ	Kazakhstan	RO	Romania		
CU	Cuba	LC	Saint Lucia	RU	Russian Federation		
CZ	Czech Republic	LI	Liechtenstein	SD	Sudan		
DE	Germany	LK	Sri Lanka	SE	Sweden		
DK	Denmark	LR	Liberia	SG	Singapore		
EE	Estonia						

## ABSORBENT ARTICLE WITH CHILD RESISTANT REFASTENABLE SEAMS

Background of the Invention

The present invention relates to absorbent articles which are adapted to contain body exudates. More particularly, the invention pertains to disposable absorbent articles that are prefastened in a pant configuration and include child resistant refastenable seams. The invention also pertains to methods of making such prefastened disposable  
5 absorbent articles.

Current disposable absorbent training pants for children going through the potty training stage have proved to be a particularly desirable and useful product. Such training pants generally include an absorbent chassis including a liquid impervious outer cover, a liquid pervious bodyside liner and an absorbent structure. The training pants further  
10 include elastic side panels that are permanently bonded to opposite side edges of the absorbent chassis. The chassis and side panels thereby form a unitary waist opening and two leg openings. The fit of the pants may be further enhanced by gathering means along the waist and leg openings.

The components of traditional training pants are permanently seamed together to  
15 provide a pant product. These products are particularly appealing to caregivers and are useful in the toilet training process because the pant has a very garment-like look. Children identify diaper products with babies, and most children do not like being identified with or as babies. Consequently, these children do not want to wear baby diapers, and instead prefer to wear training pants that look like adult underwear. Thus, the switch from  
20 a traditional diaper to a more garment-like or underwear-like training pant can be an important step in the toilet training process.

One drawback with current training pants, however, is that the manner of applying them is limited to being pulled on like a pant. Applying the product like a pant is advantageous in many instances, and is particularly suited for active, walking children.  
25 Even for the same child, however, there may be times when it would be useful to apply the product like a diaper. For instance, it might be more convenient to apply the product like a diaper when there is a desire not to remove the child's shoes. Because it is difficult to know when a particular mode of applying the garment will be needed, it is beneficial to have a garment that is adaptable to being used either as a diaper or as a pant. This is  
30 preferable to keeping both types of garments available. A product that can be applied like

either a diaper or a pant permits the interior of the product to be easily checked without having to pull the product downward.

Children, and particularly those of toilet training age, have the ability to remove disposable absorbent garments with conventional refastenable seams. For example, a child may be resistant to wearing such a garment, and thus may intentionally attempt to remove the garment. In other instances, the child may simply pick at or play with the refastenable seams of the garment in a manner which can lead to removal of the garment. In either case, the result can be undesirable.

Thus, it would be desirable to have a disposable absorbent article that provides the garment-like look of a traditional training pant, includes refastenable fastening components to allow application like either a diaper or a pant, yet minimizes the likelihood that the child will be able to disengage the fastening components without assistance from a caregiver.

#### Summary of the Invention

In response to the above-referenced unfulfilled need in the art, a new prefastened disposable absorbent article with child resistant refastenable seams and a method of making such a prefastened disposable absorbent article have been discovered. The absorbent article includes a mechanical fastening system that can be repeatedly fastened, unfastened and refastened. In addition, the front and back waist regions are adhesively bonded together in a manner that minimizes the likelihood that the child will be able to remove the absorbent article without assistance from a caregiver. The absorbent article can still be removed easily by the caregiver or with the assistance of the caregiver.

In one embodiment, the present invention relates to an absorbent article that is prefastened in a pant configuration. The absorbent article includes an absorbent chassis that defines a longitudinal axis, a transverse axis, first and second longitudinally spaced waist regions, and a crotch region which extends between and interconnects the waist regions. The absorbent article also includes at least one mechanical fastening component disposed in the first waist region and at least one mating mechanical fastening component disposed in the second waist region. The fastening component and the mating fastening component are refastenably engaged to form a refastenable mechanical seam. The first waist region of the absorbent article overlaps the second waist region and forms an overlapping flap located transversely outward from the refastenable mechanical seam. To inhibit child access to the refastenable seam, the overlapping flap is adhesively bonded to the second waist region.

The fastening components and the mating fastening components form refastenable mechanical seams for securing the first and second waist regions together. The refastenable seams allow the product to be either pulled on like a pant or applied like a diaper. If the training pant becomes soiled during use, the fastening components can be  
5 disengaged from the mating fastening components to easily remove the training pant from the waist of the wearer with reduced risk of undesirably soiling the clothes or legs of the wearer. Further, the fastening components can also be easily disengaged to inspect the training pant for possible soiling. Thus, the training pant is configured to be pulled on or off  
10 over the hips of the wearer such as conventional training pants and can be readily applied or removed by disengaging the fastening system similar to conventional diapers. Moreover, the mechanical fasteners can be repositioned if necessary after the training pant has been pulled on over the legs and hips of the wearer.

Access to the refastenable mechanical seam is blocked because the waist regions are additionally adhesively bonded together. The fastening components in the first waist  
15 region are spaced inward slightly from the side edges of the absorbent chassis. This forms an overlapping flap, which in particular embodiments has a width dimension from about 1 to about 15 millimeters, and particularly from about 2 to about 10 millimeters. The overlapping flap is adhesively bonded to the second waist region so that the child cannot insert his or her fingers between the overlapping waist regions in order to separate the  
20 mechanical fastening components from the mating mechanical fastening components. Advantageously, adhesively bonding the overlapping flap to the opposite waist region also improves the appearance of the training pant, in that it more closely resembles underwear.

The adhesive can be applied initially to one or both of the waist regions, which are  
25 joined together when the mechanical fasteners are engaged. The adhesive can be applied either continuously or discontinuously, for example, in the form of lines, dots, strands, swirls, sprays, meltblown sprays, or the like. The adhesive can be applied adjacent to the mechanical fasteners, or at least partially on one or more of the mechanical fasteners. In particular embodiments, the adhesive is one that remains tacky after application so that  
30 the first and second waist regions are refastenably bonded together by the adhesive. In this case, the refastenable mechanical and adhesive seams can be disengaged from one another, for example to inspect the interior of the garment, and then refastened for subsequent use.

In another embodiment, the present invention relates to a prefastened absorbent  
35 article including an absorbent chassis that defines a longitudinal axis, a transverse axis, opposite inner and outer surfaces, longitudinally opposed first and second waist edges,

transversely opposed side edges, a first waist region contiguous with the first waist edge, a second waist region contiguous with the second waist edge, and a crotch region which extends between and interconnects the waist regions. The first waist region of the absorbent chassis overlaps the second waist region. At least one mechanical fastening component is disposed on the inner surface in the first waist region, and at least one mating mechanical fastening component is disposed on the outer surface in the second waist region. The fastening component and the mating fastening component are refastenably engaged to form a refastenable mechanical seam that maintains the absorbent article in a pant configuration. An adhesive, which is transversely located between the refastenable mechanical seam and at least one of the side edges, releasably bonds the first and second waist region together.

In order to block access to the mechanical fasteners, the absorbent articles may additionally or alternatively include adhesives disposed longitudinally inward and/or longitudinally outward from the mechanical fastening components. Hence, in a further embodiment, the present invention relates to a prefastened an absorbent article including an absorbent chassis. The absorbent chassis includes an absorbent assembly and defines a longitudinal axis, a transverse axis, opposite inner and outer surfaces, longitudinally opposed first and second waist edges, transversely opposed side edges, a first waist region contiguous with the first waist edge, a second waist region contiguous with the second waist edge, and a crotch region which extends between and interconnects the waist regions. The first waist region includes side panels which extend transversely outward from the absorbent assembly. The side panels overlap the second waist region and define a distal edge and opposite connecting edges. Mechanical fastening components are disposed on the inner surface of the side panels in close proximity to the distal edge, and at least one mating mechanical fastening component is disposed on the outer surface in the second waist region. The mechanical fastening components and the mating mechanical fastening component are refastenably engaged to form a refastenable mechanical seam that maintains the absorbent article in the pant configuration. An adhesive that is located between the refastenable mechanical seam and at least one of the opposite connecting edges releasably bonds the first and second waist regions together.

The refastenable mechanical seams are desirably relatively thin, narrow and flexible to afford the look and feel of a cloth garment. Thus, in particular embodiments, the refastenable seams have a length-to-width ratio of about 2 or greater, such as about 2 to about 25, particularly about 5 or greater, such as about 5 to about 8. The refastenable seams define a length dimension and a width dimension that is perpendicular to the length

dimension. For a child of about 9 to about 15 kilograms (20-34 lbs.), for example, the length dimension is desirably from about 5 to about 13 centimeters, such as about 10 centimeters, and the width dimension is desirably from about 0.5 to about 3 centimeters, such as about 2 centimeters. Desirably although not necessarily, the length dimension can be aligned generally parallel to the longitudinal axis of the absorbent article and the width dimension can be aligned generally parallel to the transverse axis of the absorbent article. The term "generally parallel" as used herein refers to an angle within about 35 degrees or less of the referenced axis, and more particularly within about 20 degrees or less of the referenced axis.

The fastening components and mating fastening components desirably comprise mechanical fastening elements rather than adhesive fastening elements. Suitable mechanical fastening elements may be provided by interlocking geometric shaped materials, such as hooks, loops, bulbs, mushrooms, arrowheads, balls on stems, male and female mating components, buckles, snaps, or the like. In particular embodiments, the fastening components and mating fastening components comprise hook-and-loop fastening elements. One skilled in the art will recognize that the shape, density and polymer composition of the hooks and loops may be selected to obtain the desired level of securement between the fastening components and the mating fastening components. A more aggressive hook material may comprise a material with a greater average hook height, a greater percentage of directionally-aligned hooks, or a more aggressive hook shape.

In particular embodiments, each of the fastening components and mating fastening components defines a length dimension aligned generally parallel with the longitudinal axis of the training pant and a width dimension aligned generally parallel with the transverse axis of the training pant. For a child of about 9 to about 15 kilograms (20-30 lbs.), for example, the length dimension of the fastening components and mating fastening components is desirably from about 5 to about 13 centimeters, such as about 10 centimeters, and the width dimension is desirably from about 0.5 to about 3 centimeters, such as about 1 centimeter. The fastening components and mating fastening components desirably have a length-to-width ratio of about 2 or greater, such as about 2 to about 25, and particularly about 5 or greater, such as about 5 to about 8.

As disclosed in copending U.S. Patent Application Serial No. 60/112,709, filed on December 18, 1998 by C. P. Olson et al. and titled "Absorbent Articles Having Differential Strength Refastenable Seam," the refastenable seam can include one or more main refastenable attachment zones and one or more enhanced refastenable attachment zones. The main and enhanced refastenable attachment zones can be constructed to

provide differential levels of securement, and particularly augmented levels of securement at locations which are subject to greater levels of separation forces.

As disclosed in copending U.S. Patent Application Serial No. 60/112,775, filed on December 18, 1998 by C. P. Olson and titled "Absorbent Articles Having Hinged Fasteners," the refastenable seam can comprise individual fastening materials with narrow spacings therebetween. The narrow spacings provide a desirable hinge to improve fit and securement of the fastening components.

The disclosed absorbent articles are adapted to be worn adjacent to the body of a wearer to absorb and contain various exudates discharged from the body. The absorbent articles are desirably pre-fastened to provide a pant-like product for the user. The product can then be pulled on like a conventional training pant, and subsequently checked or removed with the ease of a diaper-like product. Moreover, the product may be applied like a diaper rather than like a pant. Supplemental releasable fastening means such as frangible point bonds may be employed to maintain the absorbent article in a pant configuration until the user intentionally disengages the fasteners.

The fastening system allows for easy inspection of the interior of the pant-like product. If necessary, the fastening system also allows the pant to be removed quickly and easily. This is particularly beneficial when the pant contains messy excrement. If desired, the caregiver can completely remove the pant-like product and replace it with a new one without having to remove the child's shoes and clothing. The present fastening system may be used with a wide variety of absorbent products, including training pants, diapers, incontinence garments, or other garments using mechanical or adhesive fasteners.

To assist with removal of the garment, the fastening system can include an interior finger tab that the caregiver can grasp when initiating separation of the mechanical fasteners. The interior finger tab can assist the caregiver with disengagement of the mechanical fasteners but is likely to go unnoticed by the child wearer. In embodiments where the first waist region overlaps the second waist region, the mating fastening components on the second waist region can be spaced transversely inward from the side edges of the absorbent chassis such that an interior finger tab is formed between the mating fastening components and the side edges. The interior finger tab will be available to the caregiver at the waist opening and/or the leg openings to assist the caregiver in separating the mechanical fasteners.

The present invention also pertains to a method of making a prefastened absorbent article. In one embodiment, a method of making a prefastened absorbent article comprises: providing an absorbent chassis defining a longitudinal axis, a transverse



axis, first and second waist edges parallel to the transverse axis, opposite side edges extending between the first and second waist edges, a first waist region contiguous with the first waist edge, a second waist region contiguous with the second waist edge, and a crotch region which extends between and interconnects the first and second waist regions; attaching a pair of mechanical fastening components to the absorbent chassis in the first waist region, the mechanical fastening components spaced from the opposite side edges to form overlapping flaps having a width from about 1 to about 15 millimeters; providing at least one mating mechanical fastening component in the second waist region, the mechanical fastening components adapted to refastenably engage the at least one mating mechanical fastening component; overlapping the first waist region onto the second waist region; refastenably engaging the mechanical fastening components and the at least one mating fastening components; and adhesively bonding the overlapping flaps to the second waist region.

A more detailed description of the construction and design of one form of training pant can be found in U.S. Patent 4,940,464 issued July 10, 1990 to Van Gompel et al., which is incorporated herein by reference. The Van Gompel et al. patent describes various materials of which the training pant can be made, and a method of constructing a training pant. In general, the various components of the training pant can be assembled employing various types of suitable attachment means, such as adhesive, sonic and thermal bonds or combinations thereof.

### Definitions

Within the context of this specification, each term or phrase below will include the following meaning or meanings.

"Bonded" refers to the joining, adhering, connecting, attaching, or the like, of two elements. Two elements will be considered to be bonded together when they are bonded directly to one another or indirectly to one another, such as when each is directly bonded to intermediate elements.

"Cohesive" describes a material or composition that is self-sticking in that it only adheres to itself.

"Comprising" is inclusive or open-ended and does not exclude additional, unrecited elements or method steps.

"Connected" refers to the joining, adhering, bonding, attaching, or the like, of two elements. Two elements will be considered to be connected together when they are connected directly to one another or indirectly to one another, such as when each is directly connected to intermediate elements.

"Disposable" refers to articles which are designed to be discarded after a limited use rather than being laundered or otherwise restored for reuse.

"Disposed," "disposed on," and variations thereof are intended to mean that one element can be integral with another element, or that one element can be a separate structure bonded to or placed with or placed near another element.

"Elastic," "elasticized" and "elasticity" mean that property of a material or composite by virtue of which it tends to recover its original size and shape after removal of a force causing a deformation.

"Elastomeric" refers to a material or composite which can be elongated by at least 25 percent of its relaxed length and which will recover, upon release of the applied force, at least 10 percent of its elongation. It is generally preferred that the elastomeric material or composite be capable of being elongated by at least 100 percent, more preferably by at least 300 percent, of its relaxed length and recover, upon release of an applied force, at least 50 percent of its elongation.

"Fabrics" is used to refer to all of the woven, knitted and nonwoven fibrous webs.

"Flexible" refers to materials which are compliant and which will readily conform to the general shape and contours of the wearer's body.

"Force" includes a physical influence exerted by one body on another, which produces acceleration of bodies that are free to move and deformation of bodies that are not free to move. Force is expressed in grams per unit area.

"Graphic" refers to any design, pattern, or the like that is visible on an absorbent article.

"Hydrophilic" describes fibers or the surfaces of fibers which are wetted by the aqueous liquids in contact with the fibers. The degree of wetting of the materials can, in turn, be described in terms of the contact angles and the surface tensions of the liquids and materials involved. Equipment and techniques suitable for measuring the wettability of particular fiber materials or blends of fiber materials can be provided by a Cahn SFA-222 Surface Force Analyzer System, or a substantially equivalent system. When measured with this system, fibers having contact angles less than 90° are designated "wetable" or hydrophilic, while fibers having contact angles greater than 90° are designated "nonwetable" or hydrophobic.

"Integral" is used to refer to various portions of a single unitary element rather than separate structures bonded to or placed with or placed near one another.

"Inward" and "outward" refer to positions relative to the center of an absorbent article and particularly transversely and/or longitudinally closer to or away from the longitudinal and transverse center of the absorbent article.

"Layer" when used in the singular can have the dual meaning of a single element or a plurality of elements.

"Liquid impermeable", when used in describing a layer or multi-layer laminate, means that a liquid, such as urine, will not pass through the layer or laminate, under  
5 ordinary use conditions, in a direction generally perpendicular to the plane of the layer or laminate at the point of liquid contact. Liquid, or urine, may spread or be transported parallel to the plane of the liquid impermeable layer or laminate, but this is not considered to be within the meaning of "liquid impermeable" when used herein.

"Longitudinal" and "transverse" have their customary meaning, as indicated by the  
10 longitudinal and transverse axes depicted in Figures 2 and 3. The longitudinal axis lies in the plane of the article and is generally parallel to a vertical plane that bisects a standing wearer into left and right body halves when the article is worn. The transverse axis lies in the plane of the article generally perpendicular to the longitudinal axis. The article as illustrated is longer in the longitudinal direction than in the transverse direction.

15 "Member" when used in the singular can have the dual meaning of a single element or a plurality of elements.

"Nonwoven web" means a web of material which is formed without the aid of a textile weaving or knitting process.

"Operatively joined," with reference to the attachment of an elastic member to  
20 another element, means that the elastic member when attached to or connected to the element, or treated with heat or chemicals, by stretching, or the like, gives the element elastic properties; and with reference to the attachment of a non-elastic member to another element, means that the member and element can be attached in any suitable manner that permits or allows them to perform the intended or described function of the  
25 joiner. The joining, attaching, connecting or the like can be either directly, such as joining either member directly to an element, or can be indirectly by means of another member disposed between the first member and the first element.

"Outer cover graphic" refers to a graphic that is directly visible upon inspection of the exterior surface of a garment, and for a refastenable garment is in reference to  
30 inspection of the exterior surface of the garment when the fastening system is engaged as it would be during use.

"Permanently bonded" refers to the joining, adhering, connecting, attaching, or the like, of two elements of an absorbent garment such that the elements tend to be and remain bonded during normal use conditions of the absorbent garment.

"Refastenable" refers to the property of two elements being capable of releasable attachment, separation, and subsequent releasable reattachment without substantial permanent deformation or rupture.

"Releasably attached," "releasably engaged" and variations thereof refer to two elements being connected or connectable such that the elements tend to remain connected absent a separation force applied to one or both of the elements, and the elements being capable of separation without substantial permanent deformation or rupture. The required separation force is typically beyond that encountered while wearing the absorbent garment.

"Rupture" means the breaking or tearing apart of a material; in tensile testing, the term refers to the total separation of a material into two parts either all at once or in stages, or the development of a hole in some materials.

"Stretch bonded" refers to an elastic member being bonded to another member while the elastic member is extended at least about 25 percent of its relaxed length. Desirably, the term "stretch bonded" refers to the situation wherein the elastic member is extended at least about 100 percent, and more desirably at least about 300 percent, of its relaxed length when it is bonded to the other member.

"Stretch bonded laminate" refers to a composite material having at least two layers in which one layer is a gatherable layer and the other layer is an elastic layer. The layers are joined together when the elastic layer is in an extended condition so that upon relaxing the layers, the gatherable layer is gathered.

"Surface" includes any layer, film, woven, nonwoven, laminate, composite, or the like, whether pervious or impervious to air, gas, and/or liquids.

"Tension" includes a uniaxial force tending to cause the extension of a body or the balancing force within that body resisting the extension.

"Thermoplastic" describes a material that softens when exposed to heat and which substantially returns to a nonsoftened condition when cooled to room temperature.

These terms may be defined with additional language in the remaining portions of the specification.

#### Brief Description of the Drawings

The above-mentioned and other features of the present invention and the manner of attaining them will become more apparent, and the invention itself will be better understood by reference to the following description and the accompanying drawings, wherein similar features in different figures have been given the same reference numeral.

Figure 1 illustrates a side view of one type of disposable absorbent article incorporating the principles of the present invention, where the fastening system is shown engaged on one side of the absorbent article and disengaged on the other side of the absorbent article.

5        Figure 2 illustrates a plan view of the disposable absorbent article shown in Figure 1 in an unfastened, stretched and laid flat condition, and showing the surface of the article that faces away from the wearer.

      Figure 3 illustrates a plan view similar to Figure 2, but showing the surface of the article that faces the wearer when the article is worn, and with portions cut away to show  
10      the underlying features.

      Figure 4A schematically illustrates an enlarged sectional view of a portion of the absorbent article of Figure 1, depicting the back waist region being overlapped with the front waist region.

      Figure 4B is similar to Figure 4A but depicting the back waist region overlapping  
15      and refastenably engaged with the front waist region.

      Figure 5 illustrates an enlarged side view of the absorbent article of Figure 1, showing the back waist region overlapping and refastenably engaged with the front waist region.

      Figure 6A schematically illustrates an enlarged sectional view of an alternative  
20      absorbent article, depicting the back waist region being overlapped with the front waist region.

      Figure 6B is similar to Figure 6A but depicting the back waist region overlapping and refastenably engaged with the front waist region.

      Figure 7A schematically illustrates an enlarged sectional view of an alternative  
25      absorbent article, depicting the back waist region being overlapped with the front waist region.

      Figure 7B is similar to Figure 7A but depicting the back waist region overlapping and refastenably engaged with the front waist region.

      Figure 8 illustrates an enlarged side view similar to Figure 5 but showing an  
30      alternative absorbent article.

      Figure 9 illustrates an enlarged side view similar to Figures 5 and 8 but showing a further alternative absorbent article.

#### Detailed Description of the Drawings

35      The principles of the present invention can be incorporated into any suitable disposable absorbent article and its method of manufacture. Examples of such suitable

articles include diapers, training pants, feminine hygiene products, incontinence products, other personal care or health care garments, or the like. For ease of explanation, the description hereafter will be in terms of a child's training pant.

With reference to Figure 1, a disposable absorbent article, such as a training pant 20, is illustrated in a partially fastened condition. The training pant 20 comprises an absorbent chassis 32 and a fastening system 80. The absorbent chassis 32 defines a front waist region 22, a back waist region 24, a crotch region 26 interconnecting the front and back waist regions, an inner surface 28 which is configured to contact the wearer, and an outer surface 30 opposite the inner surface which is configured to contact the wearer's clothing. With additional reference to Figures 2 and 3, the absorbent chassis 32 also defines a pair of transversely opposed side edges 36 and a pair of longitudinally opposed waist edges, which are designated front waist edge 38 and back waist edge 39. The front waist region 22 is contiguous with the front waist edge 38, and the back waist region 24 is contiguous with the back waist edge 39.

The illustrated absorbent chassis 32 comprises a rectangular composite structure 33, a pair of transversely opposed front side panels 34, and a pair of transversely opposed back side panels 134. The composite structure 33 and side panels 34 and 134 may be integrally formed or comprise two or more separate elements, as shown in Figure 1. The illustrated composite structure 33 comprises an outer cover 40, a bodyside liner 42 (Figures 1 and 3) which is connected to the outer cover in a superposed relation, an absorbent assembly 44 (Figure 3) which is located between the outer cover and the bodyside liner, and a pair of containment flaps 46 (Figure 3). The absorbent chassis 32 need not have side panels in both waist regions 22 and 24. Moreover, the side panels 34 and 134 can comprise an integral portion of a component of the composite structure 33, such as the bodyside liner 42 or a layer of the outer cover 40; or comprise a separate element bonded to the composite structure; or comprise a plurality of layers, whether integral portions, separate elements, or a combination thereof. The side panels 34 and 134 can comprise elastic materials, inelastic materials, or combinations of elastic and inelastic materials.

The rectangular composite structure 33 has opposite linear end edges 45 that form portions of the front and back waist edges 38 and 39, and opposite linear side edges 47 that form portions of the side edges 36 of the absorbent chassis 32 (Figures 2 and 3). For reference, arrows 48 and 49 depicting the orientation of the longitudinal axis and the transverse axis, respectively, of the training pant 20 are illustrated in Figures 2 and 3.

With the training pant 20 in the fastened position as partially illustrated in Figure 1, the front and back waist regions 22 and 24 are joined together to define a three

dimensional pant configuration having a waist opening 50 and a pair of leg openings 52. The front waist region 22 comprises the portion of the training pant 20 which, when worn, is positioned on the front of the wearer while the back waist region 24 comprises the portion of the training pant which, when worn, is positioned on the back of the wearer. The crotch region 26 of the training pant 20 comprises the portion of the training pant which, when worn, is positioned between the legs of the wearer and covers the lower torso of the wearer. The front and back side panels 34 and 134 comprise the portions of the training pant 20 which, when worn, are positioned on the hips of the wearer.

The front waist region 22 of the absorbent chassis 32 includes the transversely opposed front side panels 34 and a front center panel 35 (Figures 2 and 3) positioned between and connecting the side panels. The back waist region 24 of the absorbent chassis 32 includes the transversely opposed back side panels 134 and a back center panel 135 (Figures 2 and 3) positioned between and connecting the side panels. The waist edges 38 and 39 of the absorbent chassis 32 are configured to encircle the waist of the wearer when worn and provide the waist opening 50 which defines a waist perimeter dimension. Portions of the transversely opposed side edges 36 in the crotch region 26 generally define the leg openings 52.

The absorbent chassis 32 is configured to contain and/or absorb any body exudates discharged from the wearer. For example, the absorbent chassis 32 desirably although not necessarily comprises the pair of containment flaps 46 which are configured to provide a barrier to the transverse flow of body exudates. A flap elastic member 53 (Figure 3) is operatively joined with each containment flap 46 in any suitable manner as is well known in the art. The elasticized containment flaps 46 define an unattached edge which assumes an upright, generally perpendicular configuration in at least the crotch region 26 of the training pant 20 to form a seal against the wearer's body. The containment flaps 46 can be located along the transversely opposed side edges of the absorbent chassis 32, and can extend longitudinally along the entire length of the absorbent chassis or may only extend partially along the length of the absorbent chassis. Suitable constructions and arrangements for the containment flaps 46 are generally well known to those skilled in the art and are described in U.S. Patent 4,704,116 issued November 3, 1987 to Enloe, which is incorporated herein by reference.

To further enhance containment and/or absorption of body exudates, the training pant 20 desirably includes a front waist elastic member 54, a rear waist elastic member 56, and leg elastic members 58, as are known to those skilled in the art (Figure 3). The waist elastic members 54 and 56 can be operatively joined to the outer cover 40 and/or bodyside liner 42 along the opposite waist edges 38 and 39, and can extend over part or

all of the waist edges. The leg elastic members 58 are desirably operatively joined to the outer cover 40 and/or bodyside liner 42 along the opposite side edges 36 and positioned in the crotch region 26 of the training pant 20. The leg elastic members 58 are desirably longitudinally aligned along each side edge 47 of the composite structure 33. Each leg elastic member 58 has a front terminal point 63 and a back terminal point 65, which points represent the longitudinal ends of the elastic gathering caused by the leg elastic members. The front terminal points 63 are desirably located adjacent the longitudinally innermost parts of the front side panels 34, and the back terminal points 65 are desirably located adjacent the longitudinally innermost parts of the back side panels 134.

The flap elastic members 53, the waist elastic members 54 and 56, and the leg elastic members 58 can be formed of any suitable elastic material. As is well known to those skilled in the art, suitable elastic materials include sheets, strands or ribbons of natural rubber, synthetic rubber, or thermoplastic elastomeric polymers. The elastic materials may be stretched and adhered to a substrate, adhered to a gathered substrate, or adhered to a substrate and then elasticized or shrunk, for example with the application of heat; such that elastic constrictive forces are imparted to the substrate. In one particular embodiment, for example, the leg elastic members 58 comprise a plurality of dry-spun coalesced multifilament spandex elastomeric threads sold under the trade name LYCRA® and available from E. I. Du Pont de Nemours and Company, Wilmington, Delaware, U.S.A.

The outer cover 40 desirably comprises a material that is substantially liquid impermeable. The outer cover 40 can be a single layer of liquid impermeable material, but desirably comprises a multi-layered laminate structure in which at least one of the layers is liquid impermeable. For instance, the outer cover 40 can include a liquid permeable outer layer and a liquid impermeable inner layer that are suitably joined together by a laminate adhesive (not shown). Suitable laminate adhesives, which can be applied continuously or intermittently as beads, a spray, parallel swirls, or the like, can be obtained from Findley Adhesives, Inc., of Wauwatosa, Wisconsin, U.S.A., or from National Starch and Chemical Company, Bridgewater, New Jersey, U.S.A. The liquid permeable outer layer can be any suitable material and desirably one that provides a generally cloth-like texture. One example of such a material is a 20 gsm (grams per square meter) spunbond polypropylene nonwoven web. The outer layer may also be made of those materials of which liquid permeable bodyside liner 42 is made. While it is not a necessity for outer layer to be liquid permeable, it is desired that it provides a relatively cloth-like texture to the wearer.



The inner layer of the outer cover 40 can be both liquid and vapor impermeable, or can be liquid impermeable and vapor permeable. The inner layer is desirably manufactured from a thin plastic film, although other flexible liquid impermeable materials may also be used. The inner layer, or the liquid impermeable outer cover 40 when a single layer, prevents waste material from wetting articles, such as bedsheets and clothing, as well as the wearer and caregiver. A suitable liquid impermeable film for use as liquid impermeable inner layer, or a single layer liquid impermeable outer cover 40, is a 1.0 mil polyethylene film commercially available from Edison Plastics Company of South Plainfield, New Jersey, U.S.A. If the outer cover 40 is a single layer of material, it can be embossed and/or matte finished to provide a more cloth-like appearance. As earlier mentioned, the liquid impermeable material can permit vapors to escape from the interior of the disposable absorbent article, while still preventing liquids from passing through the outer cover 40. A suitable "breathable" material is composed of a microporous polymer film or a nonwoven fabric that has been coated or otherwise treated to impart a desired level of liquid impermeability. A suitable microporous film is a PMP-1 film material commercially available from Mitsui Toatsu Chemicals, Inc., Tokyo, Japan, or an XKO-8044 polyolefin film commercially available from 3M Company, Minneapolis, Minnesota, U.S.A.

As shown in Figures 1 and 2, the training pant 20 and in particular the outer cover 40 desirably comprises one or more appearance-related components. Examples of appearance-related components include, but are not limited to, graphics; highlighting or emphasizing leg and waist openings in order to make product shaping more evident or visible to the user; highlighting or emphasizing areas of the product to simulate functional components such as elastic leg bands, elastic waistbands; simulated "fly openings" for boys, ruffles for girls; highlighting areas of the product to change the appearance of the size of the product; registering wetness indicators, temperature indicators, and the like in the product; registering a back label, or a front label, in the product; and registering written instructions at a desired location in the product.

The illustrated training pant 20, which is designed for use by young girls, includes a registered outer cover graphic 60. In this design, the registered graphic 60 includes simulated a primary pictorial image 61, waist ruffles 62, and simulated leg ruffles 64. The primary pictorial image 61 includes a rainbow, sun, clouds, animal characters, wagon and balloons. Any suitable design can be utilized for a training pant intended for use by young girls, so as to be aesthetically and/or functionally pleasing to them and the caregiver. The appearance-related components are desirably positioned on the training pant 20 at selected locations, which can be carried out using the methods disclosed in U.S. Patent

5,766,389 issued June 16, 1998 to Brandon et al., which is incorporated herein by reference. The primary pictorial image 61 is desirably positioned in the front waist region 22 along the longitudinal centerline of the training pant 20.

The liquid permeable bodyside liner 42 is illustrated as overlying the outer cover 40 and absorbent assembly 44, and may but need not have the same dimensions as the outer cover 40. The bodyside liner 42 is desirably compliant, soft feeling, and non-irritating to the child's skin. Further, the bodyside liner 42 can be less hydrophilic than the absorbent assembly 44, to present a relatively dry surface to the wearer and permit liquid to readily penetrate through its thickness.

The bodyside liner 42 can be manufactured from a wide selection of web materials, such as synthetic fibers (for example, polyester or polypropylene fibers), natural fibers (for example, wood or cotton fibers), a combination of natural and synthetic fibers, porous foams, reticulated foams, apertured plastic films, or the like. Various woven and nonwoven fabrics can be used for the bodyside liner 42. For example, the bodyside liner can be composed of a meltblown or spunbonded web of polyolefin fibers. The bodyside liner can also be a bonded-carded web composed of natural and/or synthetic fibers. The bodyside liner can be composed of a substantially hydrophobic material, and the hydrophobic material can, optionally, be treated with a surfactant or otherwise processed to impart a desired level of wettability and hydrophilicity. For example, the material can be surface treated with about 0.28 weight percent of a surfactant commercially available from the Rohm and Haas Co. under the trade designation Triton X-102. The surfactant can be applied by any conventional means, such as spraying, printing, brush coating or the like. The surfactant can be applied to the entire bodyside liner 42 or can be selectively applied to particular sections of the bodyside liner, such as the medial section along the longitudinal centerline.

A suitable liquid permeable bodyside liner 42 is a nonwoven bicomponent web having a basis weight of about 27 gsm. The nonwoven bicomponent can be a spunbond bicomponent web, or a bonded carded bicomponent web. Suitable bicomponent staple fibers include a polyethylene/polypropylene bicomponent fiber available from CHISSO Corporation, Osaka, Japan. In this particular bicomponent fiber, the polypropylene forms the core and the polyethylene forms the sheath of the fiber. Other fiber orientations are possible, such as multi-lobe, side-by-side, end-to-end, or the like.

The absorbent assembly 44 (Figure 3) is positioned between the outer cover 40 and the bodyside liner 42, which components can be joined together by any suitable means such as adhesives as is well known in the art. The absorbent assembly 44 can be any structure which is generally compressible, conformable, non-irritating to the child's

skin, and capable of absorbing and retaining liquids and certain body wastes. The absorbent assembly 44 can be manufactured in a wide variety of sizes and shapes, and from a wide variety of liquid absorbent materials commonly used in the art. For example, the absorbent assembly 44 may suitably comprise a matrix of hydrophilic fibers, such as a web of cellulosic fluff, mixed with particles of a high-absorbency material commonly known as superabsorbent material. In a particular embodiment, the absorbent assembly 44 comprises a matrix of cellulosic fluff, such as wood pulp fluff, and superabsorbent hydrogel-forming particles. The wood pulp fluff may be exchanged with synthetic, polymeric, meltblown fibers or with a combination of meltblown fibers and natural fibers. The superabsorbent particles may be substantially homogeneously mixed with the hydrophilic fibers or may be nonuniformly mixed. The fluff and superabsorbent particles may also be selectively placed into desired zones of the absorbent assembly 44 to better contain and absorb body exudates. The concentration of the superabsorbent particles may also vary through the thickness of the absorbent assembly 44. Alternatively, the absorbent assembly 44 may comprise a laminate of fibrous webs and superabsorbent material or other suitable means of maintaining a superabsorbent material in a localized area.

Suitable superabsorbent materials can be selected from natural, synthetic, and modified natural polymers and materials. The superabsorbent materials can be inorganic materials, such as silica gels, or organic compounds, such as crosslinked polymers. Suitable superabsorbent materials are available from various commercial vendors, such as Dow Chemical Company located in Midland, Michigan, U.S.A., and Stockhausen GmbH & Co. KG, D-47805 Krefeld, Federal Republic of Germany. Typically, a superabsorbent material is capable of absorbing at least about 15 times its weight in water, and desirably is capable of absorbing more than about 25 times its weight in water.

In one embodiment, the absorbent assembly 44 is generally rectangular in shape, and comprises a blend of wood pulp fluff and superabsorbent material. One preferred type of fluff is identified with the trade designation CR1654, available from Kimberly-Clark Corporation, Neenah, Wisconsin, U.S.A., and is a bleached, highly absorbent sulfate wood pulp containing primarily soft wood fibers. As a general rule, the superabsorbent material is present in the absorbent assembly 44 in an amount of from about 5 to about 90 weight percent based on total weight of the absorbent assembly. The absorbent assembly 44 suitably has a density within the range of about 0.10 to about 0.35 grams per cubic centimeter. The absorbent assembly 44 may or may not be wrapped or encompassed by a suitable tissue wrap that maintains the integrity and/or shape of absorbent assembly.

The absorbent chassis 32 can also incorporate other materials that are designed primarily to receive, temporarily store, and/or transport liquid along the mutually facing surface with absorbent assembly 44, thereby maximizing the absorbent capacity of absorbent assembly. One suitable material is referred to as a surge layer (not shown) and comprises a material having a basis weight of about 50 grams per square meter, and comprising a through-air-bonded-carded web of a homogenous blend of 60 percent 3 denier bicomponent fiber comprising a polyester core/polyethylene sheath, commercially available from BASF Corporation, and 40 percent 6 denier polyester fiber, commercially available from Hoechst Celanese Corporation, Portsmouth, Virginia U.S. A.

As noted previously, the illustrated training pant 20 has front and back side panels 34 and 134 disposed on each side of the absorbent chassis 32. Alternatively, the training pant 20 may include side panels that extend outward from the composite structure 33 in only one of the waist regions 22 or 24. These transversely opposed front side panels 34 and transversely opposed back side panels 134 can be permanently bonded to the composite structure 33 of the absorbent chassis 32 in the respective front and back waist regions 22 and 24, and are releasably attached to one another by the fastening system 80. More particularly, as shown best in Figures 2 and 3, the front side panels 34 can be permanently bonded to and extend transversely beyond the linear side edges 47 of the composite structure 33 in the front waist region 22 along attachment lines 66, and the back side panels 134 can be permanently bonded to and extend transversely beyond the linear side edges of the composite structure in the back waist region 24 along attachment lines 66. The side panels 34 and 134 can be attached using attachment means known to those skilled in the art such as adhesive, thermal or ultrasonic bonding.

The illustrated side panels 34 and 134 each define a distal edge 68 that is spaced from the attachment line 66 and opposite connecting edges 70 and 72 on either side of the distal edge. The connecting edges 70 and 72 are identified more specifically herein as the leg end edge 70 which is disposed toward the longitudinal center of the training pant 20 and the waist end edge 72 which is disposed toward a longitudinal end of the training pant. In the illustrated embodiment, the leg end edge 70 and waist end edge 72 extend from the side edges 47 of the composite structure 33 to the distal edges 68. The leg end edges 70 of the side panels 34 and 134 form part of the side edges 36 of the absorbent chassis 32. In the back waist region 24, the leg end edges 70 are desirably angled relative to the transverse axis 49 to provide greater coverage toward the back of the pant as compared to the front of the pant. The waist end edges 72 are desirably parallel to the transverse axis 49. The waist end edges 72 of the front side panels 34 form part of the

front waist edge 38 of the absorbent chassis 32, and the waist end edges 72 of the back side panels 134 form part of the back waist edge 39 of the absorbent chassis.

Each of the side panels 34 and 134 can include one or more individual, distinct pieces of material. In particular embodiments, for example, each side panel 34 and 134 can include two or more side panel portions that are joined at one or more seams, with at least one of the portions desirably comprising an elastomeric material (not shown). Still alternatively, each individual side panel 34 and 134 can include a single piece of material which is folded over upon itself along an intermediate fold line (not shown).

The side panels 34 and 134 desirably comprise an elastic material capable of stretching in a direction parallel to the transverse axis 49 of the training pant 20. In particular embodiments, the front and back side panels 34 and 134 can each comprise an interior portion 78 (Figure 3) disposed between the distal edge 68 and the respective front or back center panel 35 or 135. In the illustrated embodiment, the interior portions 78 are disposed between the distal edges 68 and the side edges 47 of the rectangular composite structure 33. The elastic material of the side panels 34 may be disposed in the interior portions 78 to render the side panels elastomeric in a direction parallel to the transverse axis 49. Most desirably, each side panel 34 is elastomeric from the waist end edge 72 to the leg end edge 70. More specifically, individual samples of side panel material, taken between the waist end edge 72 and the leg end edge 70 parallel to the transverse axis 49 and having a length from the attachment line 66 to the distal edge 68 and a width of 2 centimeters, are all elastomeric.

In particular embodiments for improved fit and appearance, the side panels 34 and 134 desirably have a length dimension measured parallel to the longitudinal axis 48 that is about 20 percent or greater, and particularly about 25 percent or greater, of the overall length dimension of the absorbent article, also measured parallel to the longitudinal axis 48. For example, in training pants having an overall length dimension of about 54 centimeters, the side panels 34 and 134 desirably have a length dimension of about 10 centimeters or greater, such as about 15 centimeters. As illustrated the side panels 34 and 134 extend from the waist opening 50 to one of the leg openings 52.

Suitable elastic materials, as well as one described process of incorporating elastic side panels into a training pant, are described in the following U.S. Patents: 4,940,464 issued July 10, 1990 to Van Gompel et al.; 5,224,405 issued July 6, 1993 to Pohjola; 5,104,116 issued April 14, 1992 to Pohjola; and 5,046,272 issued September 10, 1991 to Vogt et al.; all of which are incorporated herein by reference. In particular embodiments, the elastic material comprises a stretch-thermal laminate (STL), a neck-bonded laminate (NBL), a reversibly necked laminate, or a stretch-bonded laminate (SBL) material.

Methods of making such materials are well known to those skilled in the art and described in U.S. Patent 4,663,220 issued May 5, 1987 to Wisneski et al.; U.S. Patent 5,226,992 issued July 13, 1993 to Mormon; and European Patent Application No. EP 0 217 032 published on April 8, 1987 in the names of Taylor et al.; all of which are incorporated  
5 herein by reference. Alternatively, the side panel material may comprise other woven or nonwoven materials, such as those described above as being suitable for the outer cover 40 or bodyside liner 42.

The training pant 20 according to the present invention also includes a fastening system 80 for securing the training pant about the waist of the wearer (Figures 2 and 3).  
10 The illustrated fastening system 80 includes first and second mechanical fastening components 82 and 83 that are adapted to refastenably connect to first and second mating mechanical fastening components 84 and 85. When the fastening components 82 and 83 and the mating fastening components 84 and 85 are releasably engaged, the absorbent article assumes a three dimensional pant configuration. In particular, the side  
15 edges 36 of the absorbent chassis 32 in the crotch region 26 define the leg openings 52, and the waist edges 38 and 39 of the absorbent chassis, including the waist end edges 72 of the side panels, define the waist opening 50. In alternative embodiments, the training pant 20 can include only a single fastening component or a single mating fastening component disposed in the waist regions 22 and 24 for refastenably connecting the waist  
20 regions together (not shown). For example, the outer cover 40 and/or the bodyside liner 42 can comprise one or more of the mechanical fasteners 82-85. Additionally, while the training pant 20 is illustrated with the back waist region 24 overlapping the front waist region 22, the position of the mechanical fasteners 82-85 could of course be reversed so that the front waist region would overlap the back waist region (not shown). The fastening  
25 components and mating fastening components 82-85 are desirably rectangular, although they may alternatively be square, round, oval, curved or otherwise nonrectangularly shaped.

In the embodiment illustrated in Figures 1-3, the exposed surfaces of each of the mating fastening components 84 and 85 desirably comprise a plurality of engaging  
30 elements that project from those surfaces. The engaging elements of these mating fastening components 84 and 85 are adapted to repeatedly engage and disengage the fastening components 82 and 83, which in this embodiment are formed by the inner surfaces 28 of the back side panels 134. For example, the first and second mating fastening components 84 and 85 can each comprise hook type fasteners and the inner  
35 surfaces 28 of the back side panels 134 can include a lofty nonwoven material that is releasably engageable with the hook type fasteners. The back side panels 134 can

comprise a variety of woven and nonwoven materials having threads or fibers of suitable size and spacing so that the inner surfaces form fastening components 82 and 83 that engage and/or entangle the engaging elements of the mating fastening components 84 and 85. The inner surfaces 28 of the back side panels 134 are desirably constructed of materials that are relatively soft against the wearer's skin and somewhat durable to provide more than one refastenable connection with the mating fastening components. The inner surfaces 28 of the back side panels 134 can comprise, for example, a spunbond material, a knit fabric, a thermal bonded carded web, a hydroentangled web, or the like that provides several engagements with the mating fastening components prior to significant destruction of the side panel material.

Hook type fasteners typically comprise a fabric or material having a base or backing structure and a plurality of hook members extending upwardly from at least one surface of the backing structure. In contrast to the loop type fasteners which desirably comprise a flexible fabric, the hook material advantageously comprises a resilient material to minimize unintentional disengagement of the fastener components as a result of the hook material becoming deformed and catching on clothing or other items. The term "resilient" as used herein refers to an interlocking material having a predetermined shape and the property of the interlocking material to resume the predetermined shape after being engaged and disengaged from a mating, complementary interlocking material. Suitable hook material may be molded or extruded of nylon, polypropylene or another suitable material. Suitable single-sided hook materials for the first fastening components 82 and 83 are available from Velcro Industries B.V., Amsterdam, Netherlands or affiliates thereof, and are identified as Velcro HTH-829 with a uni-directional hook pattern and having a thickness of about 0.089 millimeters (3.5 mils) and HTH-851 with a uni-directional hook pattern and having a thickness of about 0.051 millimeters (2 mils).

With particular reference to Figure 2, the first and second mating fastening components 84 and 85 are located on the outer surface 30 of the training pant 20 in the front waist region 22. The mating fastening components 84 and 85 are referred to as located on the outer surface 30 despite the fact that they are covered by the side panels 134 when the absorbent article is in a pant configuration. The mating fastening components 84 and 85 can be adhered to the side panels 34 or the outer surface 30 by any means known to those skilled in the art such as adhesive bonds, sonic bonds or thermal bonds.

The training pant 20 also includes an adhesive, which is shown in exaggerated size and labeled with reference numeral 90 in the Figures for purposes of explanation. The adhesive 90 can be incorporated into the training pant 20 so that it blocks easy

access to the refastenable mechanical seam by the child wearing the training pant. More specifically, the adhesive 90 can releasably bond the waist regions 22 and 24 together to block access to the side edges of the mechanical fastening components 82-85.

The position and function of the adhesive 90 can best be understood with additional reference to Figures 4A and 4B. Figure 4A schematically illustrates an enlarged sectional view depicting one back side panel 134 being overlapped with one front side panel 34 in preparation for releasably engaging a fastening component 83 with a mating fastening component 85. Figure 4B is similar but shows that the mechanical fasteners 83 and 85 have been refastenably engaged to maintain the training pant 20 in a pant configuration. While only one side of the training pant 20 will be discussed in relation to Figures 4A and 4B, it should be understood that the other side can be constructed in a similar manner.

The position of the adhesive 90 prior to placing the training pant 20 in a pant configuration is shown best in Figures 2 and 4A. In the illustrated embodiment, the adhesive 90 can initially be located on the outer surface 30 of the front side panels 34. The adhesive 90 is desirably located in close proximity to the mating fastening components 84 and 85, such as within 0 to about 15 millimeters of the mating fastening component, and particularly within 2 to 10 millimeters of the mating fastening component. The adhesive 90 is suitably disposed transversely inward from the mating fastening components 84 and 85. With particular reference to Figure 2, the adhesive 90 can extend parallel to the longitudinal axis 48 the same length as, and be aligned with, the length dimension of the mating fastening component 85. Alternatively, the adhesive 90 can extend longitudinally the entire distance between the connecting edges 70 and 72, or extend a distance that is less than the length dimension of the mating fastening component 85.

To form a pant configuration, the absorbent chassis 32 can be folded so that the back waist region 24 is brought into overlapping engagement with the front waist region 22 (Figure 1). This process is illustrated by the arrow 92 in Figure 4A, which suggests relative movement of the back side panel 134 toward the front side panel 34. In the pant configuration, the fastening component 83 and the mating fastening component 85 are refastenably engaged, and the adhesive 90 bonds the front and back waist regions 22 and 24 together.

The position of the adhesive 90 with the training pant 30 in a pant configuration is shown best in Figure 4B, where the back waist region 24 is shown overlapping and refastenably engaged with the front waist region 22. The absorbent chassis 32 is assembled in the pant configuration so that the mating fastening component 85 engages



the back side panel 134 at a location transversely inward from the side edge 36 of the absorbent chassis, i.e., inward from the distal edge 68 of the side panel 134. The engagement of the fastening component 83 and the mating fastening component 85 forms a refastenable mechanical seam 100. The portion of the overlapping back waist region 24 that is transversely outward of the refastenable mechanical seam 100 forms an overlapping flap 102. As shown in Figure 4B, the overlapping flap 102 extends from the fastening component 83 to the side edge 36 of the absorbent chassis 32. The adhesive 90 is positioned in the training pant 20 so that it bonds the overlapping flap 102 to the opposite waist region.

In particular embodiments, the overlapping flap 102 has a width dimension measured parallel to the transverse axis 49 from about 1 to about 15 millimeters, and particularly from about 2 to about 10 millimeters. Wider overlapping flaps 102 are wasteful of side panel material and require more adhesive to bond in place. Conversely, it is more difficult to precisely located the mechanical fasteners and adhesive 90 when very narrow overlapping flaps 102 are used. The length of the overlapping flap corresponds to the longitudinal length of the side panels.

To assist with easy removal of the training pant 20 by a caregiver, the fastening system 80 can include an interior finger tab 108 (Figure 4B). The interior finger tab 108 is formed by a portion of the front waist region 22 that is disposed beneath the overlapping back waist region 24. More specifically, the mating fastening component 85 can spaced from the distal edge 68 of the front side panel 34, or more generally spaced from the side edge 36 of the absorbent chassis 32, by about 2 to about 15 millimeters, and more particularly by about 5 to about 10 millimeters. The portion of the front waist region 22 that is located between the refastenable mechanical seam 100 and thus the mating fastening component 85 and the side edge 36 of the front waist region 22 forms the interior finger tab 108.

The interior finger tab 108 is not bonded to the opposite waist region and thus can be grasped by the caregiver to facilitate disengagement of the refastenable mechanical seam 100. Because the interior finger tab 108 is not exposed on the outer surface 30 the training pant 20 when in a pant configuration, the child wearing the training pant will be unlikely to use the interior finger tab to disengage the mechanical fasteners.

An enlarged side view of one side of the training pant 20 is illustrated in Figure 5. The location of the adhesive 90 is shown by the dashed portion. In particular, the back side panel 134 overlaps the front side panel 34. The side panels 34 and 134 are shown slightly longitudinally offset from one another to clarify the position of the side panels. The

adhesive 90 bonds the overlapping flap 102 to the outer surface 30 of the front side panels 34.

An alternative embodiment of the training pant 20 is shown in Figures 6A and 6B. This embodiment is similar to that depicted in Figures 4A and 4B except for the initial position of the adhesive 90. In particular, the adhesive 90 is initially located on the inner surface 28 of the back side panels 134. The adhesive 90 is desirably positioned in close proximity to the side edge 36 in the back waist region 24 and extends transversely inward therefrom so as to bond substantially all of the overlapping flap 102 to the opposite waist region. For instance, the adhesive 90 is desirably located within 0 to about 15 millimeters of the side edge 36 in the back waist region 24, and particularly within 2 to 10 millimeters of the side edge. With the absorbent chassis 32 in the pant configuration, as illustrated in Figure 6B, the fastening component 83 is refastenably engaged with the mating fastening component 85 and the adhesive 90 bonds the front and back waist regions 22 and 24 together. The adhesive 90 is disposed between the refastenable mechanical seam 100 and the side edges 36, and can also be disposed in whole or in part within the refastenable seam.

Another alternative embodiment of the training pant 20 is shown in Figures 7A and 7B. The back side panel 134 is shown overlapped with the front side panel 34 in preparation for releasably engaging a fastening component 83 with a mating fastening component 85. In this embodiment, a separate fastening component 83 is bonded to the inner surface 28 of the back side panel 134. The fastening component 83 is desirably attached to the side panel 134 at a location transversely inward from the side edge 36, i.e., inward from the distal edge 68. In particular embodiments, the fastening component 83 is spaced transversely inward from the distal edge 68 by about 1 to about 15 millimeters, and particularly about 2 to about 10 millimeters. The portion of the back waist region 24 that is transversely outward of the fastening component 83 forms an overlapping flap 102. Specifically, the overlapping flap 102 extends from the fastening component 83 to the side edge 36 of the absorbent chassis 32.

The fastening component 83 can comprise any suitable mechanical fastening component, such as a hook type fastener or a loop type fastener. Loop type fasteners typically comprise a fabric or material having a base or backing structure and a plurality of loop members extending upwardly from at least one surface of the backing structure. The loop material can be formed of any suitable material, such as acrylic, nylon or polyester, and can be formed by methods such as warp knitting, stitch bonding or needle punching. Suitable loop materials are available from Guilford Mills, Inc., Greensboro, North Carolina, U.S.A. under the trade designation No. 36549.

In this embodiment, the adhesive 90 is initially located on the inner surface 28 of the back side panels 134 and transversely outward from the fastening component 83. The adhesive 90 is desirably located in close proximity to the fastening component 83, such as within 0 to about 15 millimeters of the fastening component, and particularly within 2 to 10 millimeters of the fastening component.

In Figure 7B, the fastening component 83 is refastenably engaged with the mating fastening component 85 and the adhesive 90 bonds the front and back waist regions 22 and 24 together. Similar to the other embodiments, with the absorbent chassis in the pant configuration, the adhesive 90 is disposed between the refastenable mechanical seam 100 and the side edges 36 of the back waist region 24 so that the overlapping flap 102 is bonded to the opposite waist region 22.

As illustrated in Figures 4, 6 and 7, the adhesive 90 can be applied initially to either or both of the waist regions 22 and 26, provided it bonds the overlapping flap 102 to the opposite waist region. Suitable adhesives are described generally as construction adhesives, and are available from various adhesive suppliers such as National Starch, Bridgewater, New Jersey, U.S.A. In one particular embodiment, the adhesive comprises an SBS block copolymer having a modulus of about  $10^9$  to  $10^{10}$  and a shear rate of 10 radians/sec, an example of which is identified as National Starch No. 345610 or 5610. The adhesive may be applied at an add-on level of about 1 gram per square meter or less, such as about 0.4 to about 0.6 grams per square meter. The particular add-on rate may vary, however, depending on the type of adhesive, method of application and type of overlapping flap material. Suitable adhesives can also include cohesives. In particular embodiments, the adhesive 90 can be selected so that it remains tacky so that it can be repeatedly engaged and disengaged.

A side view of an alternative training pant 20 is illustrated in Figure 8. Similar to Figure 5, the front and back side panels 34 and 134 are shown slightly longitudinally offset from one another to clarify the position of the side panels. In this embodiment, the adhesive is disposed in two locations represented by dashed portions 110 and 112. The adhesives 110 and 112 bond the overlapping back waist region 24 to the underlying front waist region 22.

The adhesives 110 and 112 are located between the refastenable mechanical seam 100 and the opposite connecting edges 70 and 72 of the side panels 34 and 134. More particularly, one adhesive deposit 110 is located between the refastenable mechanical seam 100 and the waist end edges 72 of the side panels 34 and 134, and the other adhesive deposit 112 is located between the refastenable mechanical seam 100 and the leg end edges of the side panels 34 and 134. The fastening components 82 and

83 and mating fastening components 84 and 85 can be spaced longitudinally inward from the leg end edge 70 and spaced longitudinally inward from the waist end edge 72 by about 2 millimeters or more, particularly about 5 millimeters or more, such as from about 5 to about 15 millimeters.

5           The first adhesive deposit 110 can be useful to prevent the refastenable mechanical seam 100 from unintentional separation forces originating at the waist opening 50 of the training pant 20. The second adhesive deposit 112 can be useful to prevent the refastenable mechanical seam 110 from unintentional separation forces originating at the leg openings 52 of the training pant 20. Such adhesive deposits 110 and  
10       112 may be particularly desirable for training pants where the refastenable mechanical seam 100 is located toward the front of the wearer rather than at the sides of the wearer, as shown in Figure 1, because seams toward the front of the wearer are more accessible to the wearer and are more subject to separation forces caused by bending at the waist of the wearer and articulation of the wearer's legs.

15           Figure 9 illustrates another alternative training pant 20. This embodiment includes adhesive in three regions 90, 110 and 112 around the refastenable mechanical seam 100. The regions 90, 110 and 112 can be discrete from or integral with one another. This embodiment provides significant protection of the refastenable mechanical seam 100, and contributes to an overall garment-like appearance of the seam. It can be advantageous for  
20       the three regions 90, 110 and 112 to be substantially continuous along the outside edge, and the bottom edge, respectively as shown in Figure 9, to block access to the refastenable seam 100 and create a garment-like appearance. An interior finger tab 108 can be included to facilitate intentional separation of the side panels 34 and 134 by the caregiver.

25           The training pant 20 may further include releasable side bonds (not shown) for improved reliability of maintaining the pant in a prefastened condition particularly when it is being pulled on or off over the hips of the wearer. Such releasable side bonds are desirably configured to be readily broken such that the caregiver can easily remove the training pant 20 after it has been soiled. The releasable side bonds desirably comprise  
30       ultrasonic point bonds. Absorbent articles including such releasable side bonds are further described in U.S. Patent Application Serial No. 09/100,574 titled "Disposable Absorbent Articles Having Passive Side Bonds And Adjustable Fastening Systems" filed June 19, 1998 by Elsberg, which is incorporated herein by reference.

35           It will be appreciated that details of the foregoing embodiments, given for purposes of illustration, are not to be construed as limiting the scope of this invention. Although only a few exemplary embodiments of this invention have been described in detail above,

those skilled in the art will readily appreciate that many modifications are possible in the exemplary embodiments without materially departing from the novel teachings and advantages of this invention. Accordingly, all such modifications are intended to be included within the scope of this invention, which is defined in the following claims and all  
5 equivalents thereto. Further, it is recognized that many embodiments may be conceived that do not achieve all of the advantages of some embodiments, particularly of the preferred embodiments, yet the absence of a particular advantage shall not be construed to necessarily mean that such an embodiment is outside the scope of the present invention.

## CLAIMS:

I claim:

1. An absorbent article prefastened in a pant configuration, comprising:  
an absorbent chassis defining a longitudinal axis, a transverse axis, first and second longitudinally spaced waist regions, and a crotch region which extends between and interconnects the waist regions;  
5 at least one mechanical fastening component disposed in the first waist region;  
and  
at least one mating mechanical fastening component disposed in the second waist region, the at least one mechanical fastening component and the at least one mating mechanical fastening component being refastenably engaged to form a refastenable  
10 mechanical seam;  
wherein the first waist region overlaps the second waist region and forms an overlapping flap transversely outward from the refastenable mechanical seam, and the overlapping flap is adhesively bonded to the second waist region.
2. The absorbent article of claim 1, wherein the adhesive bond is refastenable.
3. The absorbent article of claim 1, wherein the overlapping flap has a width of about 1 to about 15 millimeters.
4. The absorbent article of claim 1, wherein the mating mechanical fastening component is spaced from a side edge of the absorbent chassis to form an interior finger tab.
5. The absorbent article of claim 1, wherein the refastenable mechanical seam defines a length dimension, a width dimension, and a length-to-width ratio of about 2 or greater.

6. An absorbent article prefastened in a pant configuration, comprising:

an absorbent chassis defining a longitudinal axis, a transverse axis, opposite inner and outer surfaces, longitudinally opposed first and second waist edges, transversely opposed side edges, a first waist region contiguous with the first waist edge, a second waist region contiguous with the second waist edge, and a crotch region which extends between and interconnects the waist regions, the first waist region overlapping the second waist region;

at least one mechanical fastening component disposed on the inner surface in the first waist region;

at least one mating mechanical fastening component disposed on the outer surface in the second waist region, the at least one mechanical fastening component and the at least one mating mechanical fastening component being refastenably engaged to form a refastenable mechanical seam that maintains the absorbent article in the pant configuration; and

an adhesive releasably bonding the first and second waist region together, the adhesive transversely located between the refastenable mechanical seam and at least one of the side edges.

7. The absorbent article of claim 6, wherein the adhesive bond is refastenable.

8. The absorbent article of claim 6, wherein the first waist region defines an overlapping flap transversely outward from the refastenable mechanical seam, the overlapping flap having a width of about 1 to about 15 millimeters.

9. The absorbent article of claim 8, wherein the first waist region defines an overlapping flap transversely outward from the refastenable mechanical seam, the overlapping flap having a width of about 2 to about 10 millimeters.

10. The absorbent article of claim 6, wherein the first waist region includes an overlapping flap transversely outward from the refastenable mechanical seam and the adhesive bonds substantially all of the overlapping flap to the second waist region.

11. The absorbent article of claim 6, wherein the first waist region comprises a pair of side panels, and one mechanical fastening component is disposed on each side panel.
12. The absorbent article of claim 11, wherein the absorbent article has an overall length dimension and the side panels have a length dimension that is about 20 percent or greater of the overall length dimension.
13. The absorbent article of claim 11, wherein the second waist region comprises a pair of side panels, and the at least one mating mechanical fastening component is disposed on the side panels in the second waist region.
14. The absorbent article of claim 11, wherein the adhesive is disposed transversely outward from the mechanical fastening components relative to the first waist region and is disposed transversely inward from the refastenable mechanical seam relative to the second waist region.
15. The absorbent article of claim 6, wherein the at least one mating fastening component is spaced from the side edge to form an interior finger tab.
16. The absorbent article of claim 15, wherein the interior finger tab has a width of about 2 to about 15 millimeters.
17. The absorbent article of claim 16, wherein the interior finger tab has a width of about 5 to about 10 millimeters.
18. The absorbent article of claim 6, wherein the adhesive is located within 0 to about 15 millimeters of the refastenable mechanical seam.
19. The absorbent article of claim 18, wherein the adhesive is located within about 2 to about 10 millimeters of the refastenable mechanical seam.
20. The absorbent article of claim 18, wherein the adhesive is located within 0 to about 15 millimeters of the at least one mechanical fastening component.
21. The absorbent article of claim 18, wherein the adhesive is located within about 2 to about 10 millimeters of the at least one mechanical fastening component.



22. The absorbent article of claim 6, wherein the refastenable mechanical seam defines a length dimension, a width dimension, and a length-to-width ratio of about 2 or greater.

23. The absorbent article of claim 22, wherein the refastenable mechanical seam has a length-to-width ratio of about 5 or greater.

24. The absorbent article of claim 6, wherein the at least one mechanical fastening component has a length dimension, a width dimension, and a length-to-width ratio of about 5 or greater.

25. The absorbent article of claim 6, wherein the at least one mechanical fastening component and the at least one mating mechanical fastening component comprise hook-and-loop materials.

26. An absorbent article prefastened in a pant configuration, comprising:

an absorbent chassis comprising an absorbent assembly and defining a longitudinal axis, a transverse axis, opposite inner and outer surfaces, longitudinally opposed first and second waist edges, transversely opposed side edges, a first waist region contiguous with the first waist edge, a second waist region contiguous with the second waist edge, and a crotch region which extends between and interconnects the waist regions, the first waist region comprising side panels which extend transversely outward from the absorbent assembly, the side panels overlapping the second waist region and defining a distal edge and opposite connecting edges;

mechanical fastening components disposed on the inner surface of the side panels in close proximity to the distal edge;

at least one mating mechanical fastening component disposed on the outer surface in the second waist region, the mechanical fastening components and the at least one mating mechanical fastening component being refastenably engaged to form a refastenable mechanical seam that maintains the absorbent article in the pant configuration; and

an adhesive releasably bonding the first and second waist region together, the adhesive located between the refastenable mechanical seam and at least one of the opposite connecting edges.

27. The absorbent article of claim 26, wherein the adhesive bond is refastenable.

28. The absorbent article of claim 26, further comprising an adhesive transversely located between the refastenable mechanical seam and at least one of the side edges.

5

29. The absorbent article of claim 26, wherein the at least one mating fastening component is spaced from the side edge to form an interior finger tab.

30. A method of making a prefastened absorbent article, the method comprising:

providing an absorbent chassis defining a longitudinal axis, a transverse axis, first and second waist edges parallel to the transverse axis, opposite side edges extending between the first and second waist edges, a first waist region contiguous with the first waist edge, a second waist region contiguous with the second waist edge, and a crotch region which extends between and interconnects the first and second waist regions;

attaching a pair of mechanical fastening components to the absorbent chassis in the first waist region; the mechanical fastening components spaced from the opposite side edges to form overlapping flaps having a width from about 2 to about 15 millimeters;

providing at least one mating mechanical fastening component in the second waist region, the mechanical fastening components adapted to refastenably engage the at least one mating mechanical fastening component;

overlapping the first waist region onto the second waist region;

refastenably engaging the mechanical fastening components and the at least one

mating fastening components; and

adhesively bonding the overlapping flaps to the second waist region.



2/8

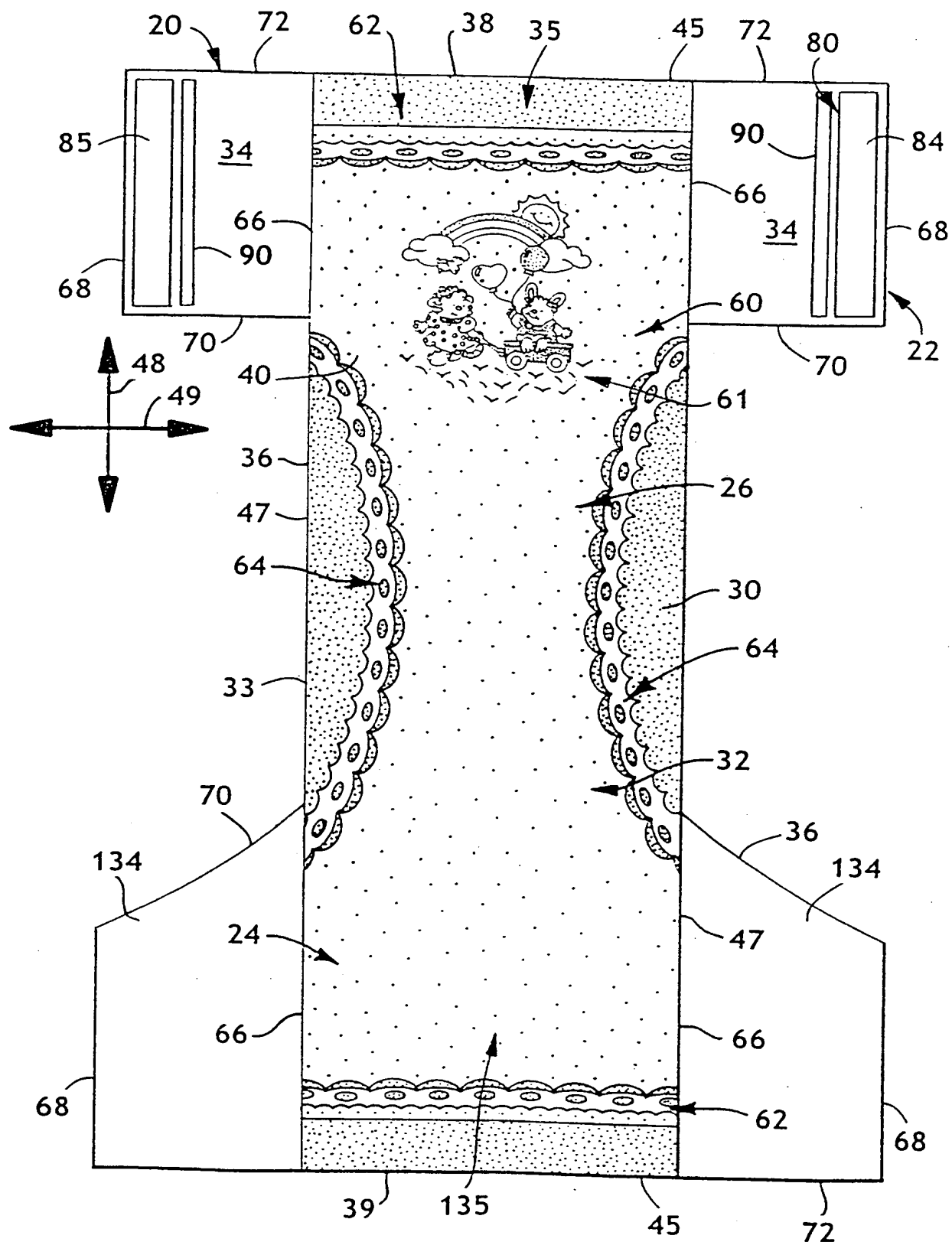


FIG. 2

3/8

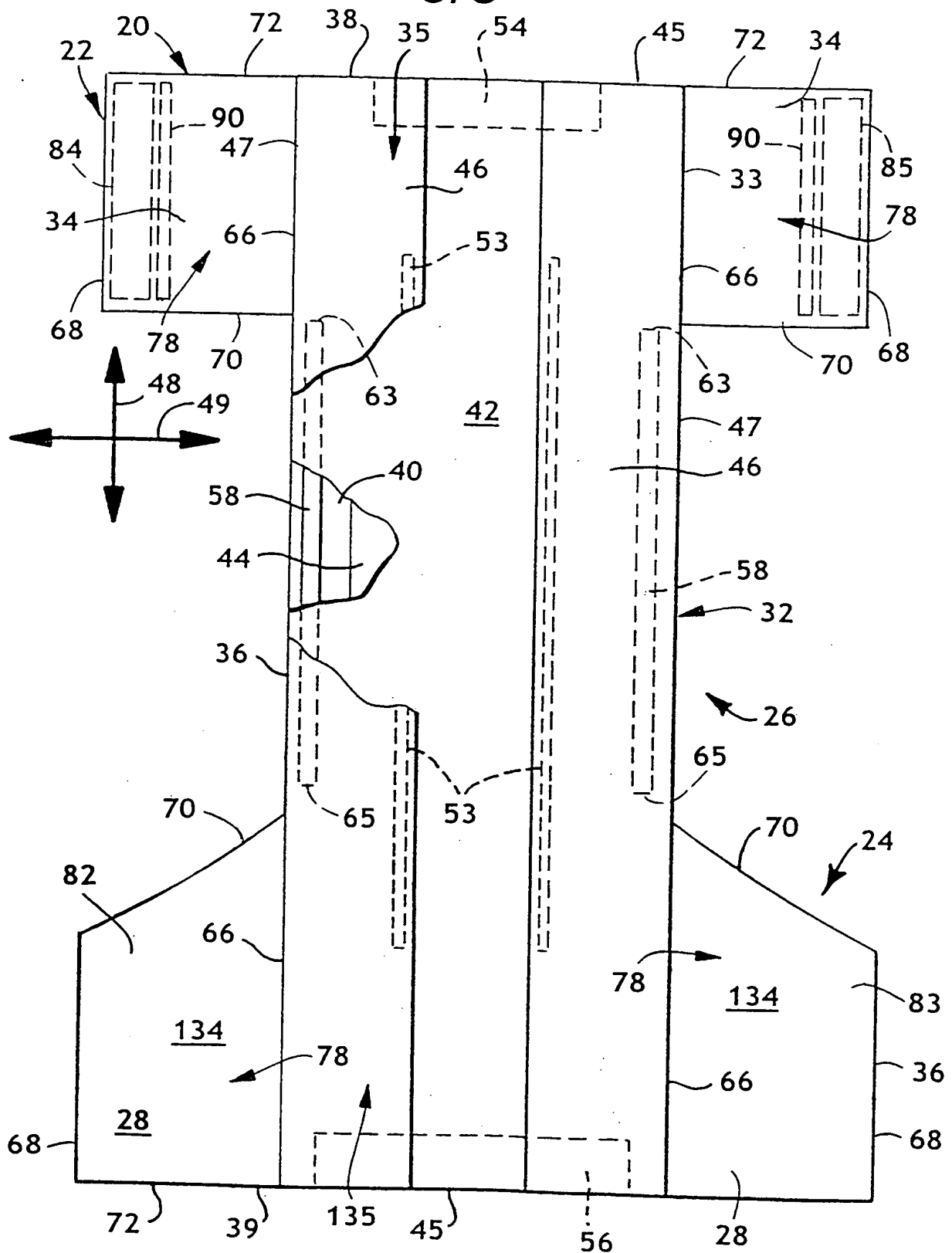


FIG. 3

4/8

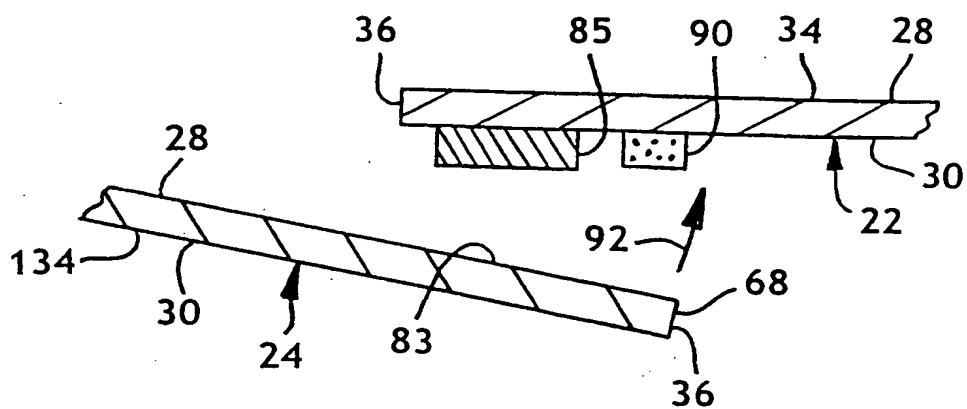


FIG. 4A

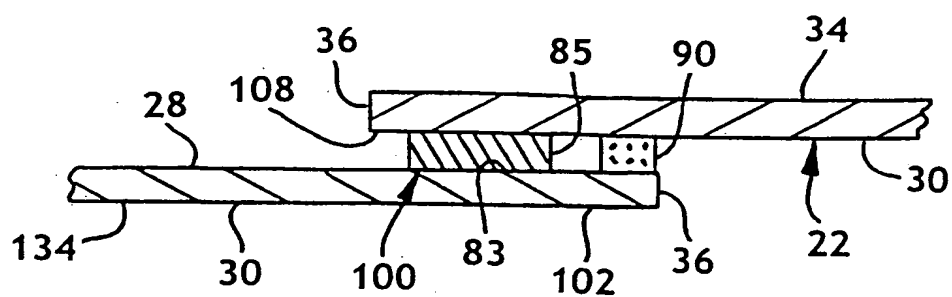
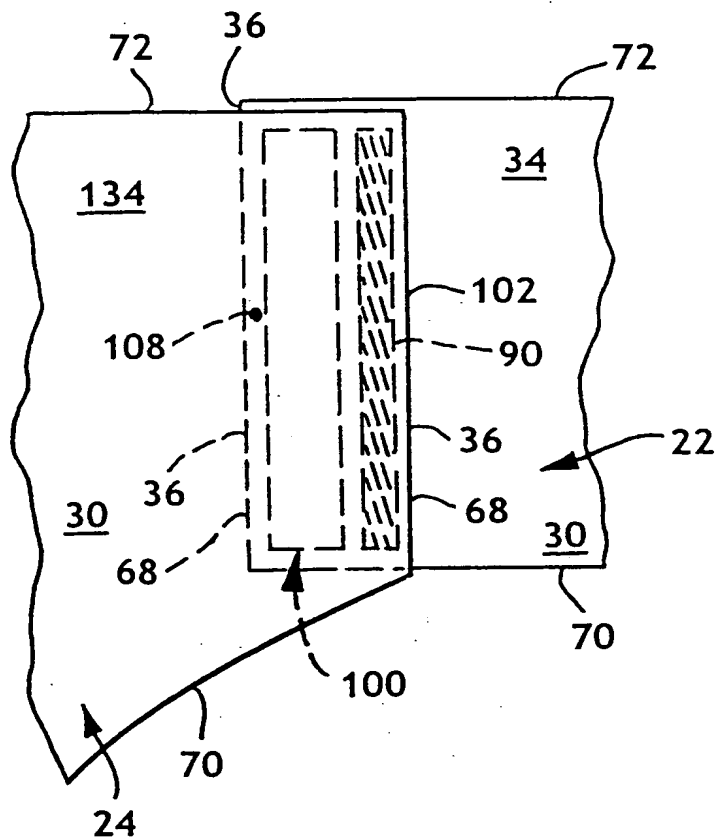


FIG. 4B

5/8



6/8

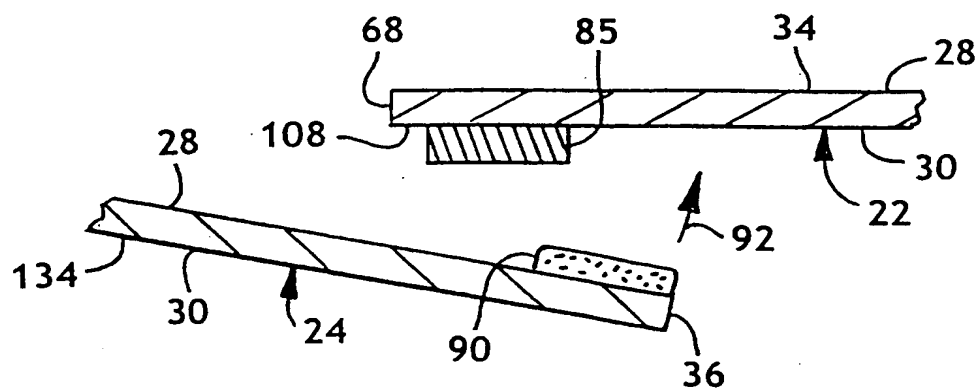


FIG. 6A

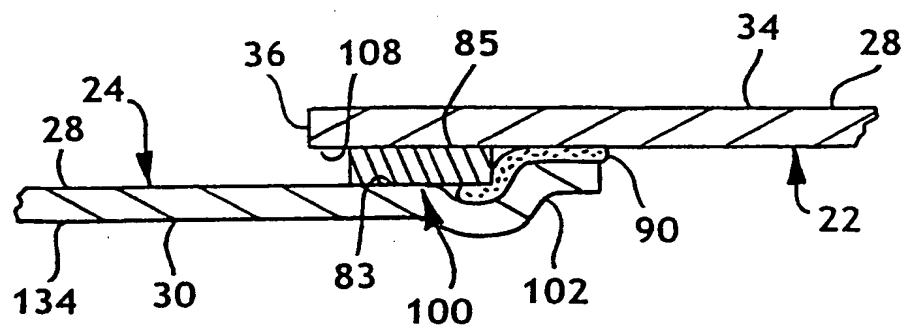


FIG. 6B



7/8

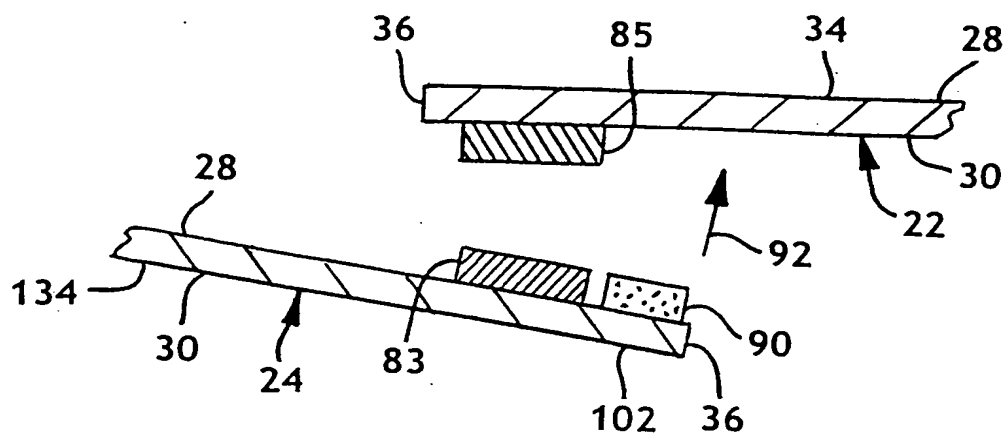


FIG. 7A

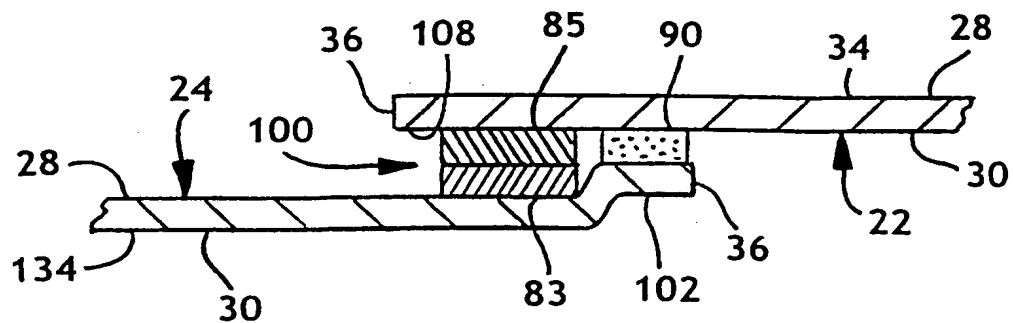


FIG. 7B

8/8

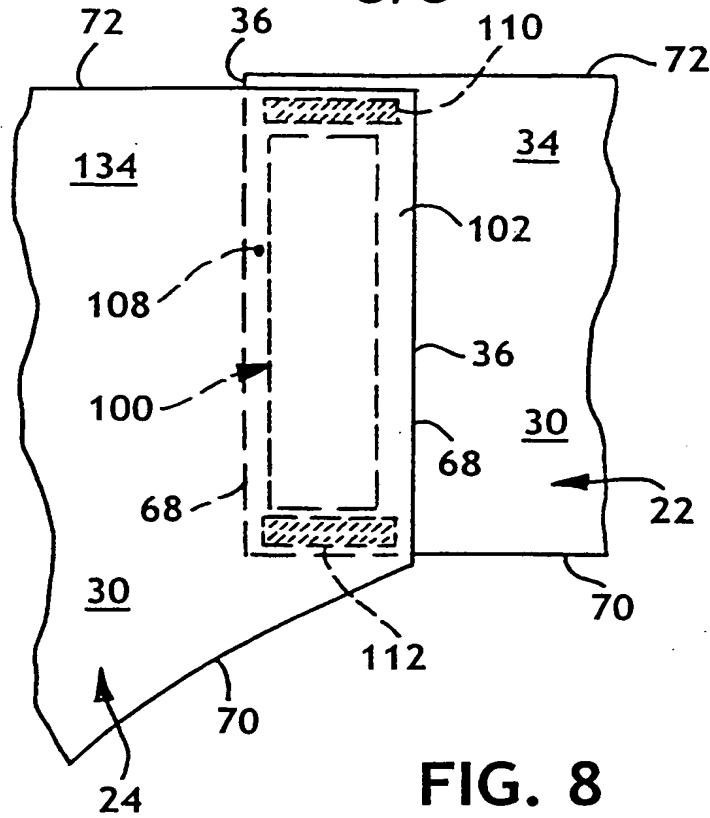


FIG. 8

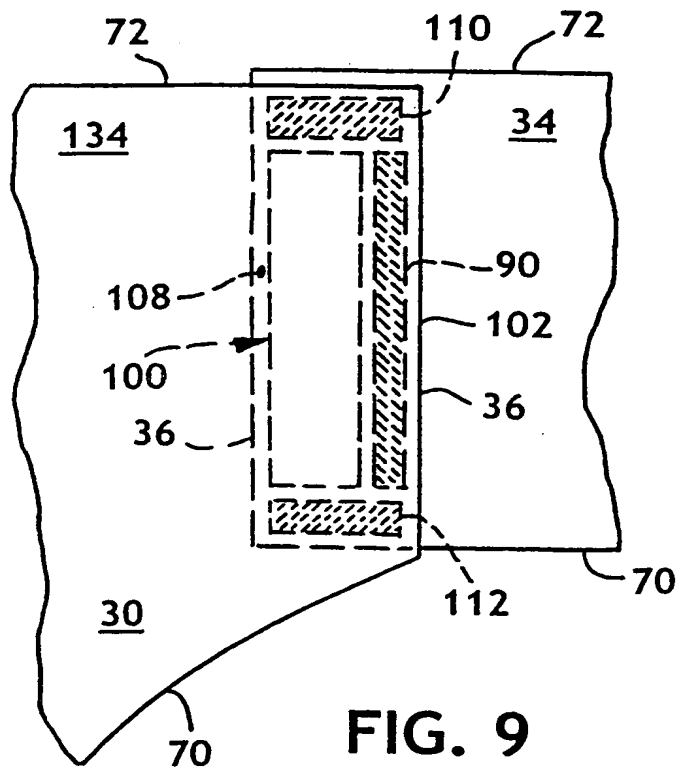


FIG. 9

# INTERNATIONAL SEARCH REPORT

Inte onal Application No

PCT/US 99/30328

## A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 A61F13/15

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 A61F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	EP 0 321 232 A (THE PROCTER & GAMBLE) 21 June 1989 (1989-06-21) column 4, line 55-63	1-3
A	column 7, line 53 -column 10, line 20; figures 1,2	6,26,30
X	EP 0 476 992 A (MINNESOTA MINING AND MANUFACTURING COMP) 25 March 1992 (1992-03-25)  page 2, line 24-56 page 3, line 12 -page 4, line 55; claim 13; figures	1-4, 6-11, 13-15, 25-30



Further documents are listed in the continuation of box C.



Patent family members are listed in annex.

\* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier document but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

29 March 2000

Date of mailing of the international search report

12/04/2000

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2  
NL - 2280 HV Rijswijk  
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,  
Fax: (+31-70) 340-3018

Authorized officer

Seabra, L

# INTERNATIONAL SEARCH REPORT

International Application No

PCT/US 99/30328

## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	US 5 087 253 A (ROSANNA COOPER) 11 February 1992 (1992-02-11) column 6, line 60 -column 7, line 68 column 10, line 10 -column 12, line 16; figures 4,7,12,16,17,19	1,6,26, 30
A	US 4 834 742 A (WILSON, STEVENS, ODORZYNSKI, SIEBERS, RAJALA) 30 May 1989 (1989-05-30) column 4, line 28 -column 5, line 4; figures 1,10	1,6,26, 30
A	US 4 650 483 A (FREDERICK JOFFE) 17 March 1987 (1987-03-17) column 5, line 12 -column 6, line 9; figures 1,5-7	1,6,26, 30

# INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/US 99/30328

Patent document cited in search report		Publication date	Patent family member(s)	Publication date
EP 0321232	A	21-06-1989	AT 89715 T	15-06-1993
			AU 628798 B	24-09-1992
			AU 2764088 A	05-07-1990
			CA 1311589 A	22-12-1992
			DE 3881358 A	01-07-1993
			GR 3007978 T	31-08-1993
			HK 95196 A	07-06-1996
			JP 2004373 A	09-01-1990
			JP 2654146 B	17-09-1997
			KR 9707094 B	02-05-1997
			US 5019065 A	28-05-1991
EP 0476992	A	25-03-1992	DE 69111347 D	24-08-1995
			DE 69111347 T	11-04-1996
			ES 2074663 T	16-09-1995
			JP 4246354 A	02-09-1992
US 5087253	A	11-02-1992	US 4615695 A	07-10-1986
US 4834742	A	30-05-1989	AU 597098 B	24-05-1990
			AU 7791087 A	10-03-1988
			CA 1286449 A	23-07-1991
			EP 0262447 A	06-04-1988
			JP 63120102 A	24-05-1988
			MX 172461 B	16-12-1993
			AT 100699 T	15-02-1994
			AU 598621 B	28-06-1990
			AU 8311987 A	07-07-1988
			BR 8707162 A	16-08-1988
			CA 1293095 A	17-12-1991
			DE 3788951 D	10-03-1994
			DE 3788951 T	05-05-1994
			EP 0274753 A	20-07-1988
			ES 2048152 T	16-03-1994
			JP 2541603 B	09-10-1996
			JP 63243307 A	11-10-1988
			KR 9508168 B	26-07-1995
			MX 169347 B	30-06-1993
			US 4895569 A	23-01-1990
			US 4872871 A	10-10-1989
US 4650483	A	17-03-1987	GB 2148095 A	30-05-1985